

304 3/8 OX

Work Order ID 160519

Monday, May 01, 2017 10:09:21 AM

160519

Page 1

Item ID: D3759-1 **Accept** ***N900040100*** **Setup Start *NS1***
Revision ID: **Stop *NS2***
Item Name: Bushing
Start Date: 5/5/2017 **Start Qty:** 100.00 ***100* 214** **Cust Item ID:**
Required Date: 5/9/2017 **Req'd Qty:** 100.00 ***100*** **Customer:**
Reference: SCHEDULED/S
Approvals: **Process Plan:**  **Date:** MAY 01 2017 **Tooling:** **Date:** **Run Start *NR1***
QC: **Date:** **SPC (Y/N):** **Date:** **Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3759	Rev A								

100

0.10

100

Hardinge

Hardinge CNC LATHE SMALL

Memo

4.00

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL
Turn per Folio FA727 and Dwg D3759

Deburr

214

φ

DAS
33
9-89

17/05/07

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

1.00

Quality Control

214

φ

DAS
33
9-89

17/05/07

DAS
45
9-89

17-5-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

Work Order ID 160519

Monday, May 01, 2017 10:09:21 AM

160519

Page 2

Item ID: D3759-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bushing

Start Date: 5/5/2017 Start Qty: 100.00

100

Cust Item ID:

Required Date: 5/9/2017 Req'd Qty: 100.00

100

Customer:

Reference: SCHEDULED/S

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

2.00

214

Ø

DAS

20

9-89

1705-12

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

1.00

214

DAS

6

9-89

Packaging

*****STOCK IN BASKET CELL*****
LOCATION: WA004

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

10.00

17/5/16

Quality Control

DAS
21
9-89

MAY 16 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Misabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

Picklist Print

Monday, May 01, 2017 10:09:21 AM

Page 1

Work Order ID: 160519

160519

Parent Item: D3759-1

D3759-1

Parent Item Name: Bushing

Start Date: 5/5/2017

Required Date: 5/9/2017

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP Rev:A 08-03-04 new issue DD verified by: LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			110	f	26.2000	0.0725	7.631579			

M304R0 375

304 ROUND BAR 0.375

Location

Loc Qty

Loc Code

MAT028

26.2

m137263

14.2

m137400

12

14.2**
2.2**

16.4**

DAS
45 2017-5-8
9-89

DQA: _____ Date: _____

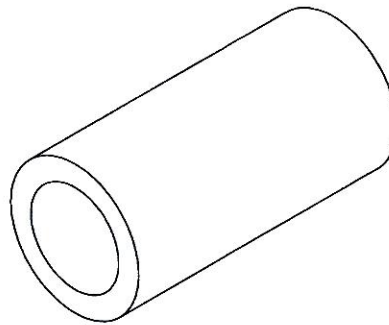


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																														



D3759-1 BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 160519 MP

MAY 01 2017

RELEASED
160519 MP

NOTES:

1) MATERIAL: AISI 304/316, STAINLESS STEEL ROD
(REF. DART SPEC M304R)
OR AISI 304/316, STAINLESS STEEL TUBE
(REF. DART SPEC M304TR)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

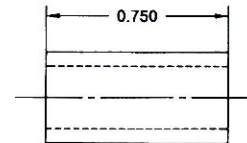
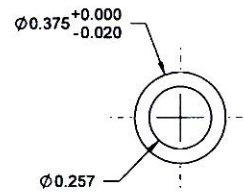
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.01 lbs

A		NEW ISSUE		AJS	08.03.03
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	ASS			SHEET 1 OF 2	
CHECKED	ME	DRAWING NO.		REV. A	
MFG. APPR.	MP	D3759		SHEET 1 OF 2	
APPROVED	MP	TITLE		SCALE	
DE APPR.	MP	BUSHING		NTS	
DATE		08.03.03		COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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D3759-1 BUSHING

08.03.03

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	AK	D3759	SHEET 2 OF 2
APPROVED	AK	TITLE	SCALE
DE APPR.	AK	BUSHING	NTS
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